












B25353

Dart Aerospace Ltd.

Date: Monday, 6/19/2006 1:26:38 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 27654		
Estimate Number	: 12451		
P.O. Number	: N/A	Part Number	: D35001
This Issue	: 6/19/2006 S.O. No. : N/A	Drawing Number	: D3500 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/26/2006 Qty: 4 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:A New Issue 06-06-15 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>SD</u> Double check by: <u>JD</u> 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>SD / JL 06/06/21</u>			
3.0	QC8	SECOND CHECK	
			
<b>Comment:</b> SECOND CHECK <u>mf 06/06/21 4</u>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>DL 06/06/22 (4)</u>			
5.0	POWDER COATING	POWDER COATING	
			
<b>Comment:</b> POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <u>DL 06/06/22 (4)</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/19/2006 1:26:38 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 27654

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06-06-22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

PROTOTYPE  
FOR SADDLE N/A 06.06.23  
TEST

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> B27654
<b>Description:</b> 350 saddle		<b>Part Number:</b> D 3500-1
<b>Inspection Dwg:</b> D3500 , Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

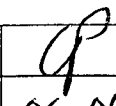


First Article



Prototype

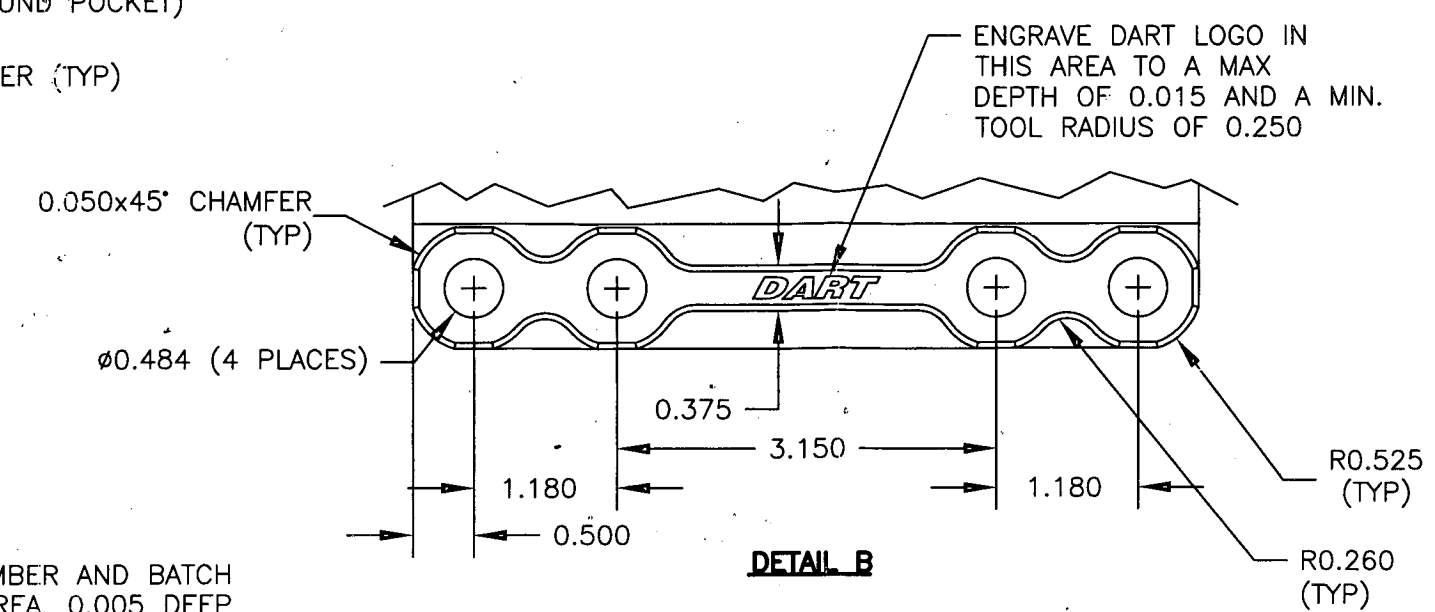
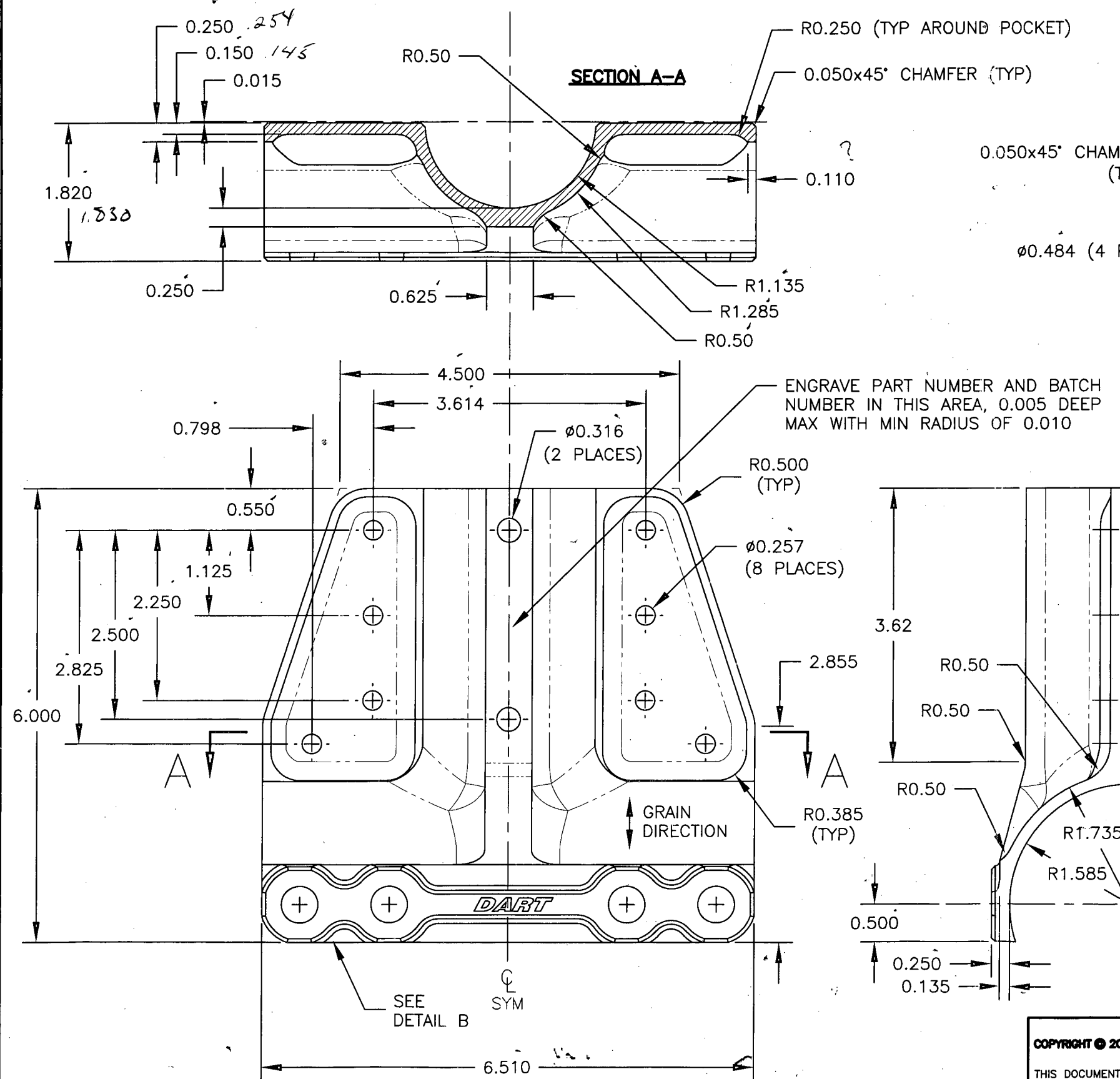
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	+ .010	.250	✓			
.150	"	.145	✓			
1.820	"	1.815	✓			
.250	"	.255	✓			
.625	"	.630	✓			
1.135	"	1.135	✓			
.110	"	.113	✓			
3.614	"	3.614	✓			
Ø.316		.319	✓			
Ø.257		.258	✓			
6.510	+ .010	6.510	✓			
6.000	"	6.005	✓			
.550	"	.552	✓			
.798	"	.797	✓			
1.125	"	1.125	✓			
2.250	"	2.250	✓			
2.500	"	2.500	✓			
2.825	"	2.829	✓			
1.585	"	1.585	✓			
.500	"	.501	✓			
.250	"	.249	✓			
Ø.484		.486	✓			
.500	+ .010	.495				

<b>Measured by:</b> J.L.	<b>Audited by:</b> ml	<b>Prototype Approval:</b> 
<b>Date:</b> 06/06/20	<b>Date:</b> 06/06/21	<b>Date:</b> 06.06.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



1.374  
1.370



**D3500-1 SADDLE**

- 1) MATERIAL: 7075-T7351 ALUMINUM (QQ-A-250/12, REF DART SPEC M7075T73B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**PRELIMINARY ISSUE**

06.06.19

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B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3500 REV. B SHEET 1 OF 1
DATE	TITLE	SCALE
06.05.29	SADDLE	2:3

06.05.09

Metay Cestle